

Work Order ID 77131

77131

Page 1

November-25-11 3:12:29 PM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 25/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/25

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750	F
D3492	C

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

8/12/22

MLJ 11-12-22

77131

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side)								

B 11/12/06

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004A/R Aluminum Rod batch: M118735 8-11-12-06

12-Grind welds flush as per Dwg D2750

B 11/12/06

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00 S 11/12/07

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00 S 11/12/07

Quality Control

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Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QS1005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

11-12-07
11/12/07

11-12-8

W/O:		WORK ORDER CHANGES					
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Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>119399</u> exp. date: <u>12-8-13</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>m118 735</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

DP 11-12-8

BE 11-12-12

K 11-12-14

W/O:		WORK ORDER CHANGES					
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1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

dwg D2750

12-Deburr holes

11-12-14

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

8 11/12/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Skidtube RH

Start Date: 25/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

①

hmf 11-12-16

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*12:00
3200 F
12:30**hmf 11/12/19*

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 hmf 11-12-21

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 25/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00

230

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"

batch: N/A

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 119443EXP DATE: 12-1

5-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 110348

6-Coat all exposed fasteners with "LPS Procyon"

batch: 114581 BL 11-12-21

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-25-11 3:12:29 PM

N900040100

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Stop ***NS2***

Start Date: 25/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 09/12/2011 **Req'd Qty:** 1.00 *** 1 ***

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Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240 QC Quality Control	Memo	0.00							
250	Pick Kit	0.00							
250 Packaging Packaging	Memo	0.00							
260	QC4- 100% Inspect kits for completeness	0.00							
260 QC Quality Control	Memo	0.00							

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Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
280	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/12/23

mf

11-12-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
IPP Rev:J 06-03-29 As per Rev D EC
IPP Rev:K 06-07-13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225

Purchased

No

Each

1,873.000

38

AI S4-1032-225

**

Insert

Location

Loc Qty

Loc Code

ST281

1873

108696

281

110768

62

118386

858

118966 ✓

672

38

AN3C5A

Purchased

No

230

Each

1,297.000

34

34

AN3C5A

**

Bolt

Location

Loc Qty

Loc Code

FP

7

115835

7

ST350

1290

116419

28

117343

17

117764

52

117872

2

118451

191

119127

500

119749 ✓

500

34

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Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

344.0000

4

4

AN3C6A

BOLT

**

BR 11-12-21

Location

Loc Qty

Loc Code

FP

1

111982

1

ST350

100

119449

100

ST351

243

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

88

119749 ✓

100

4.

AN6C44A

Purchased

No

230

Each

95.0000

4

4

AN6C44A

BOLT

**

BR 11-12-21

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

93

118985 ✓

40

119125

30

119530

23

4.

Dart Aerospace Ltd

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D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

96.0000

1

1

AN8C35A

BOLT

**

BR 11-12-21

Location

Loc Qty

Loc Code

FP

64

115960

1

118286

63

ST345

31

117834 ✓

31

ST346

1

114442

0

115188

0

115960

1

AN960C10L

X NAS1149C0332 ✓

Purchased

No

230

Each

0.0000

38

38

***AN960C10I ***

washer

D2745

Manufactured

No

230

Each

109.0000

8

8

D2745

Bushing

**

38.

BR 11-12-21

**

BR 11-12-21

Location

Loc Qty

Loc Code

FP

73

69529 ✓

1

74446 ✓

72

ST021

36

71835

36

8.

W/O:		WORK ORDER CHANGES					
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Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

22.0000

1

1

D3488-042

Blade Fitting Assembly, RH

**

BR 11-12-21

Location

Loc Qty

Loc Code

FP002

11

75068 ✓

11

FP008

11

62003

1

69904

2

71883

8

D3492-1

Manufactured No

230

Each

22.0000

8

8

D3492-1

Plug

*D 3492-041

70185.

**

BR 11-12-21

Location

Loc Qty

Loc Code

FP

22

69531

8

74444

14

D3492-3

Manufactured No

230

Each

73.0000

8

8

D3492-3

Plug

**

BR 11-12-21

Location

Loc Qty

Loc Code

FP

29

74447

29

FP-B

44

74871 ✓

44

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 77131

77131

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

27.0000

1

1

D3535-25******

Wearshoe

*BR 11-12-21*LocationLoc QtyLoc Code

FP001

17

74525

5

75040

12

FP018

10

62233

1

74592 ✓

9

1

D3536-25

Manufactured No

230

Each

31.0000

1

1

D3536-25******

Gasket

*BR 11-12-21*LocationLoc QtyLoc Code

FP012

31

74595

5

75039 ✓

26

1

D3537-1

Manufactured No

230

Each

42.0000

3

3

D3537-1******

Wearpad

*BR 11-12-21*LocationLoc QtyLoc Code

FP002

35

74436

30

74597

5

FP017

7

69817

5

70686

2

3

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 77131

77131

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

471.0000

8

8

D3631-1

Washer

**

BR 11-12-21

Location

Loc Qty

Loc Code

ST072

471

68062

2

75548 ✓

469

8

D3791-1

Manufactured No

230

Each

31.0000

1

1

D3791-1

Wearplate

**

BR 11-12-21

Location

Loc Qty

Loc Code

FP002

16

75041

16

FP017

15

62239

2

74527

1

74598 ✓

12

1

D3793-1

Manufactured No

230

Each

20.0000

1

1

D3793-1

Wearshoe

**

BR 11-12-21

Location

Loc Qty

Loc Code

FP001

12

75038

12

FP018

8

74591 ✓

8

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 77131

77131

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

24.0000

1

1

D3793-3

Wearshoe

BR 11-12-21.

Location

Loc Qty

Loc Code

FP001

24

74528 ✓

8

74593 ✓

4

75043

12

1

D3794-1

Manufactured No

230

Each

41.0000

1

1

D3794-1

Gasket

BR 11-12-21.

Location

Loc Qty

Loc Code

FP014

41

74529 ✓

1

74594 ✓

12

75042

28

1

D3794-3

Manufactured No

230

Each

23.0000

1

1

D3794-3

Gasket

BR 11-12-21.

Location

Loc Qty

Loc Code

FP002

23

74530 ✓

9

74596

14

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 77131

77131

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

437.0000

4

4

MS21043-6

**

BR 11-12-21

NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

ST300

417

112314 ✓

207

117887

10

118384

200

4

MS21083C8

Purchased

No

230

Each

87.0000

1

1

MS21083C8

**

BR 11-12-21

NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

85

115884

0

118614 ✓

32

119309

3

119436

25

119638

25

1

NAS1149C0832R

Purchased

No

230

Each

328.0000

1

1

NAS1149C0832R

**

BR 11-12-21

WASHER

Location

Loc Qty

Loc Code

ST297

328

114915 ✓

328

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 77131

77131

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

143.0000

4

4

***NAS1515H3I ***

WASHER

**

BR 11-12-21.

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

103

118686

3

119438 ✓

100

4.

NAS1611-010

Purchased

No

230

Each

211.0000

8

8

NAS1611-010

O-RING

**

BR 11-12-21.

Location

Loc Qty

Loc Code

FP

211

110915

14

117460

8

118077

1

118612

3

119438 ✓

135

119623 ✓

50

84
4.

NAS1611-013

Purchased

No

230

Each

180.0000

8

8

NAS1611-013

O-RING

**

BR 11-12-21.

Location

Loc Qty

Loc Code

FP

180

116582

5

117291

2

117887

53

119307 ✓

76

119438 ✓

2

119623

42

8
8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 77131

77131

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

61.0000

2

**

AN8C21A

BOLT

Location

Loc Qty

Loc Code

ST343

61

118045

7

118758

24

119530

30

D2741

Manufactured

No

250

Each

11.0000

1

**

D2741

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-2

71856

8

ST466

13

70667

3

D3493-1

Manufactured

No

250

Each

51.0000

2

**

D3493-1

Washer

Location

Loc Qty

Loc Code

ST062

51

70697

4

71846

17

76237

30

D3532-1

Manufactured

No

250

Each

42.0000

2

**

D3532-1

Spacer

Location

Loc Qty

Loc Code

ST065

42

73342

2

74880

40

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 77131

77131

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

87.0000

2

2

MS21083C8

NUT

**

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

85

115884

0

118614

32

119309

3

119436

25

119638

25

NAS1149D0863J

Purchased

No

250

Each

198.0000

2

2

NAS1149D0863.J

WASHER

**

Location

Loc Qty

Loc Code

ST298

198

118078

98

119307

100

D2600-3-BENT

Manufactured

No

110

Each

21.0000

1

1

D2600-3-BENT

Extrusion Bent

**

Location

Loc Qty

Loc Code

LG

21

66875

8

73253

1

75021

4

75022

7

75023

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 77131

77131

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

47.0000

1

1

D2744

Cap

**

BE11-12-06

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

34

71861

34

D2739

Manufactured No

160

Each

11.0000

1

1

D2739

350 I Beam

**

D 11-12-8

Location

Loc Qty

Loc Code

LG

11

72153

1

76140

3

76866

4

76867

3

D2743

Manufactured No

160

Each

279.0000

8

8

D2743

Crossbolt Spacer

**

BE11-12-12

Location

Loc Qty

Loc Code

LG

269

71839

5

73403

54

74445

100

76141

100

LG001

10

67766

4

68251

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 77131

77131

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured No

160

Each

74.0000

4

4

D3490-3

Cross Bolt Spacer

BEH-12-12

Location

Loc Qty

Loc Code

LG

34

76234

34

LG001

40

74877

40

4

D3490-1

Manufactured No

160

Each

98.0000

4

4

D3490-1

Cross Bolt Spacer

BEH-12-12

Location

Loc Qty

Loc Code

LG

4

67773

4

LG001

94

62450

2

74875

64

76233

28

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 77131 M.C.J.
11/11/25

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PA		
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 1 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

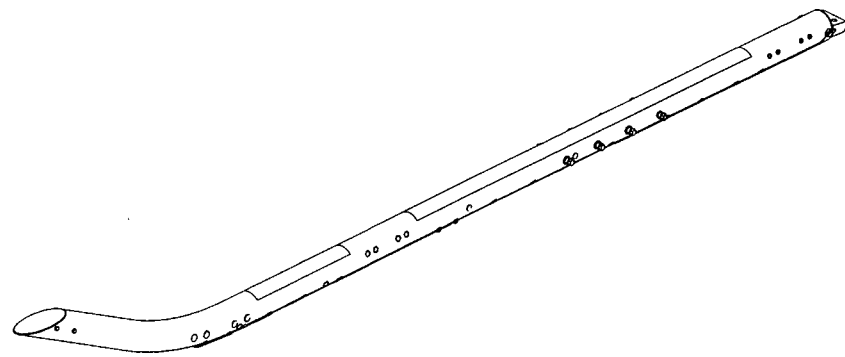
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

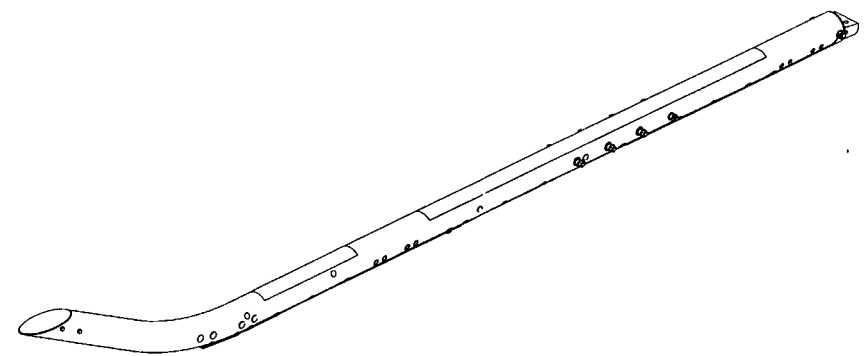
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77131



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	AD	PORT HADLOCK, WA	
CHECKED	JA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 2 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

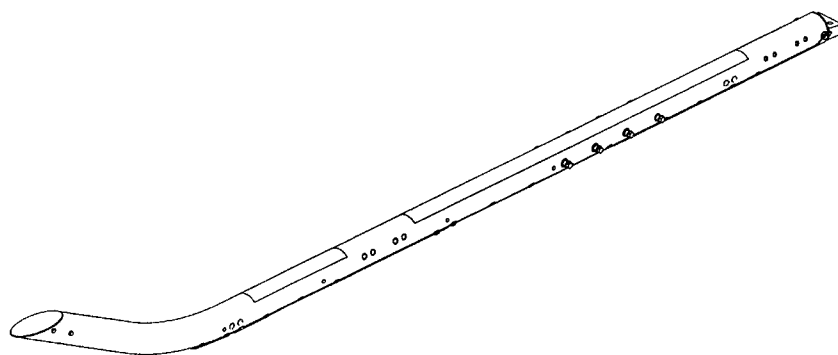
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

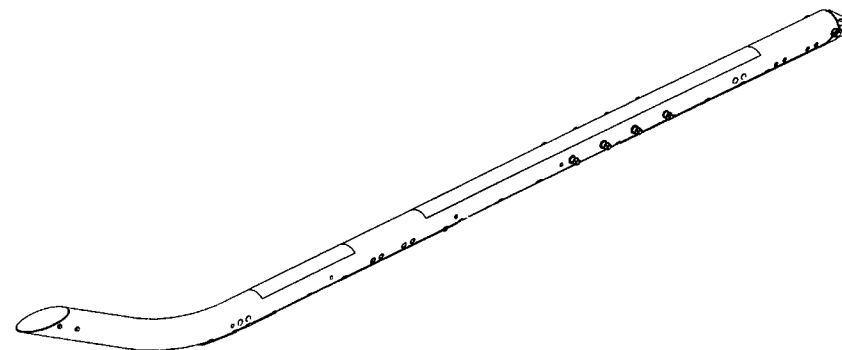
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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CHECKED	JA	DRAWING NO.	REV. F
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DE APPR.	JA	350 SKIDTUBE ASSEMBLY	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

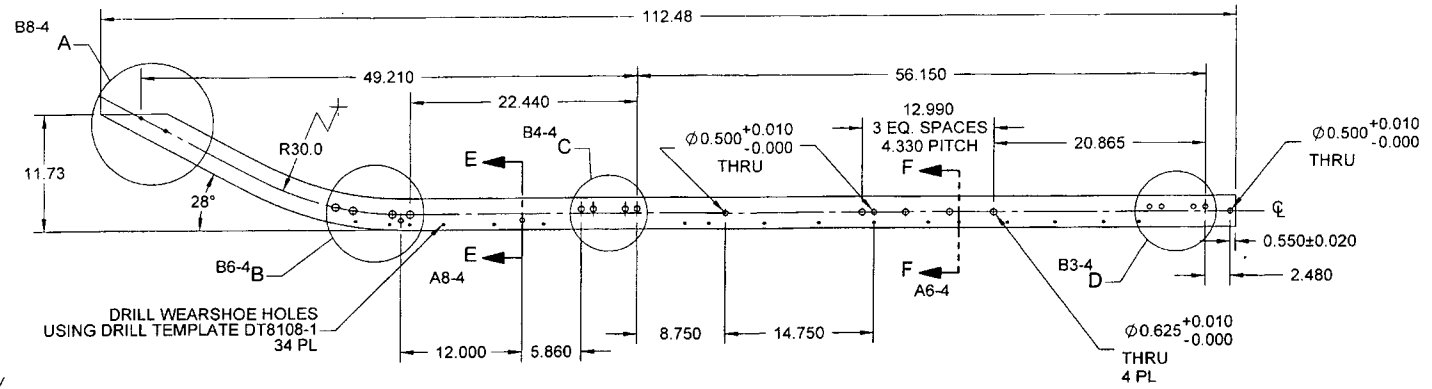
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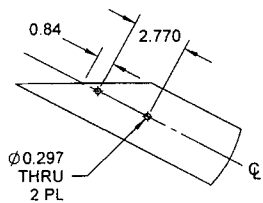
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

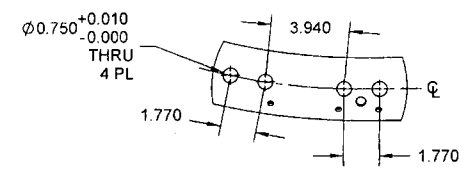
77131



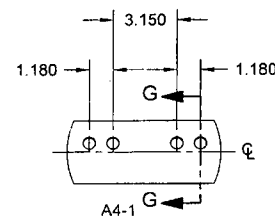
D2750-1 LH SKIDTUBE



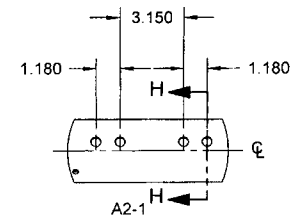
DETAIL A
SCALE 2X



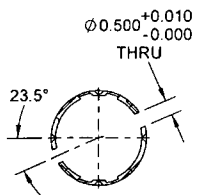
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SCALE 2X



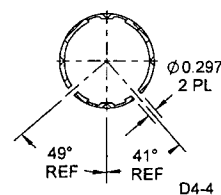
DETAIL C
SCALE 2X



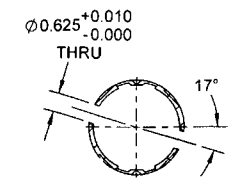
DETAIL D
SCALE 2X



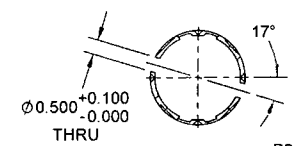
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY	SHEET 4 OF 11
APPROVED		SCALE	NTS
DE APPR.			
DATE	08.07.16		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

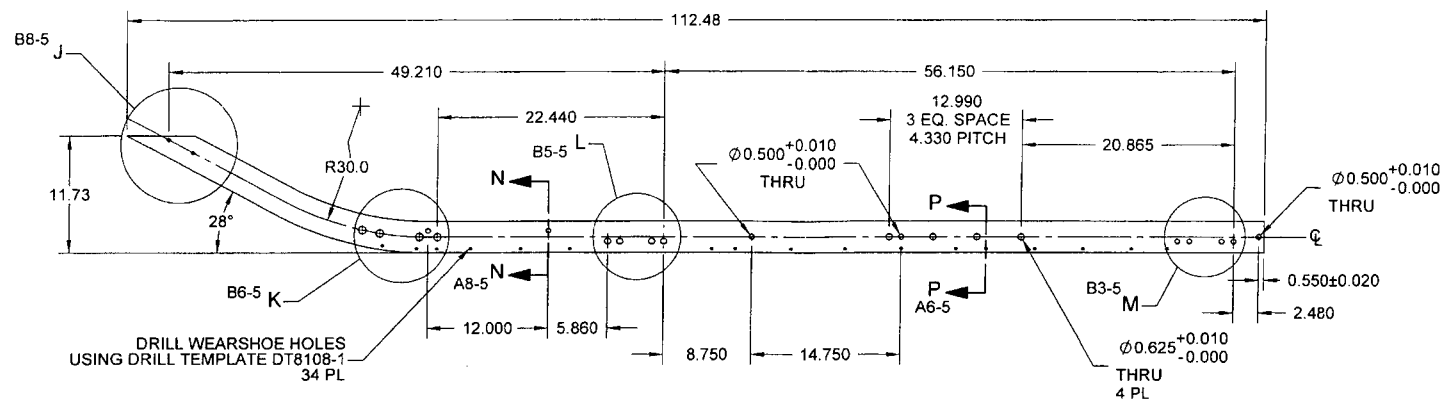
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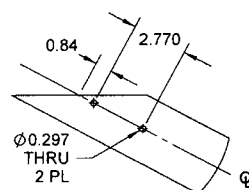
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

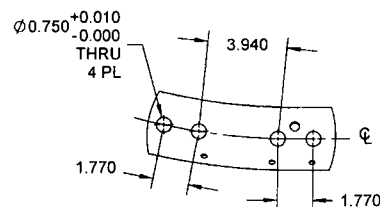
77131



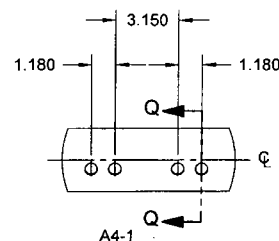
D2750-2 RH SKIDTUBE



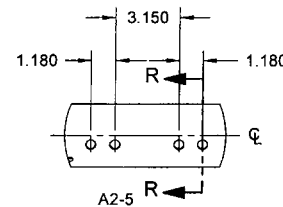
DETAIL J
SCALE 2X



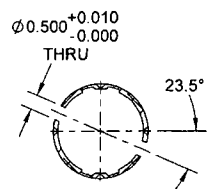
DETAIL K
SCALE 2X



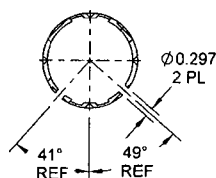
DETAIL L
SCALE 2X



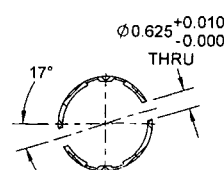
DETAIL M
SCALE 2X



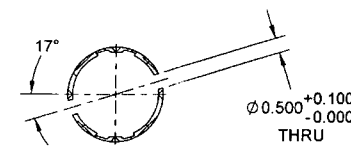
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DESIGN	REV. F	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2750 TITLE 350 SKIDTUBE ASSEMBLY DATE 08.07.16	REV. F
DRAWN	REV. F		SHEET 5 OF 11
CHECKED			SCALE
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DE APPR.			
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

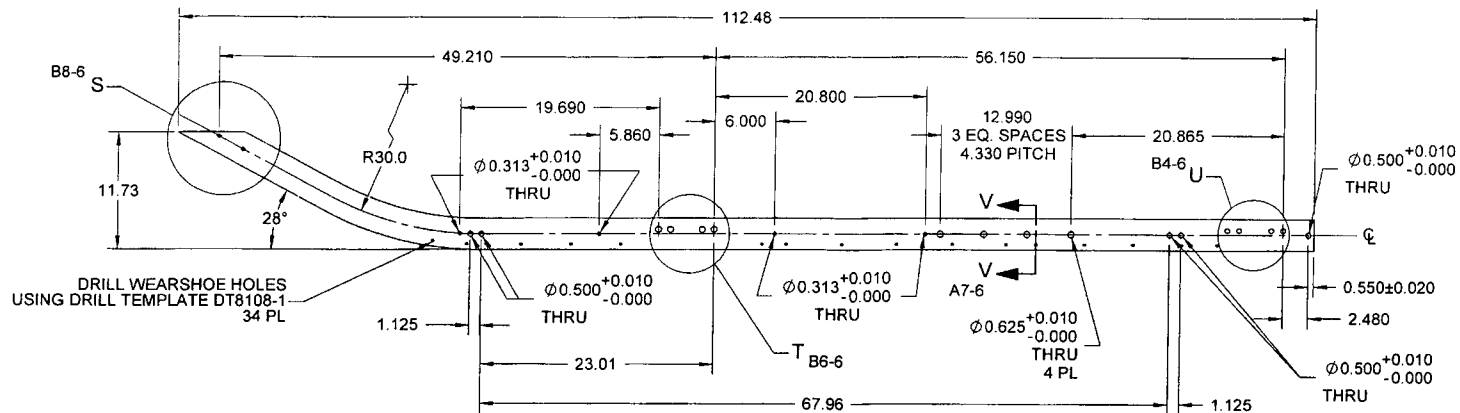
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

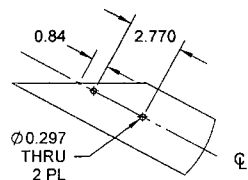
NOTE: Date & initial all entries

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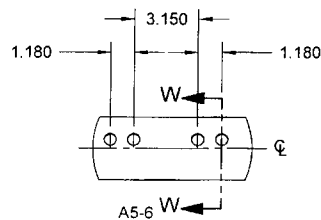
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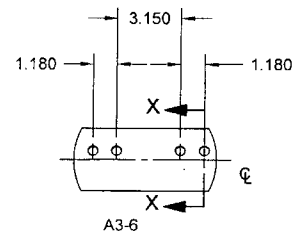
D2750-3 LH SKIDTUBE



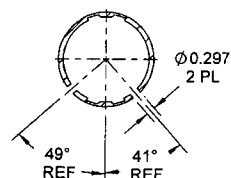
DETAIL S
D8-6
SCALE 2X



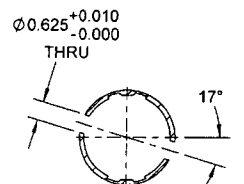
DETAIL T
C5-6
SCALE 2X



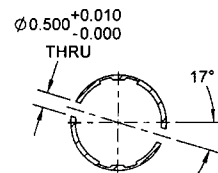
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



SECTION X-X
B4-6
SCALE 3X, 4 PL

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DESIGN		DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

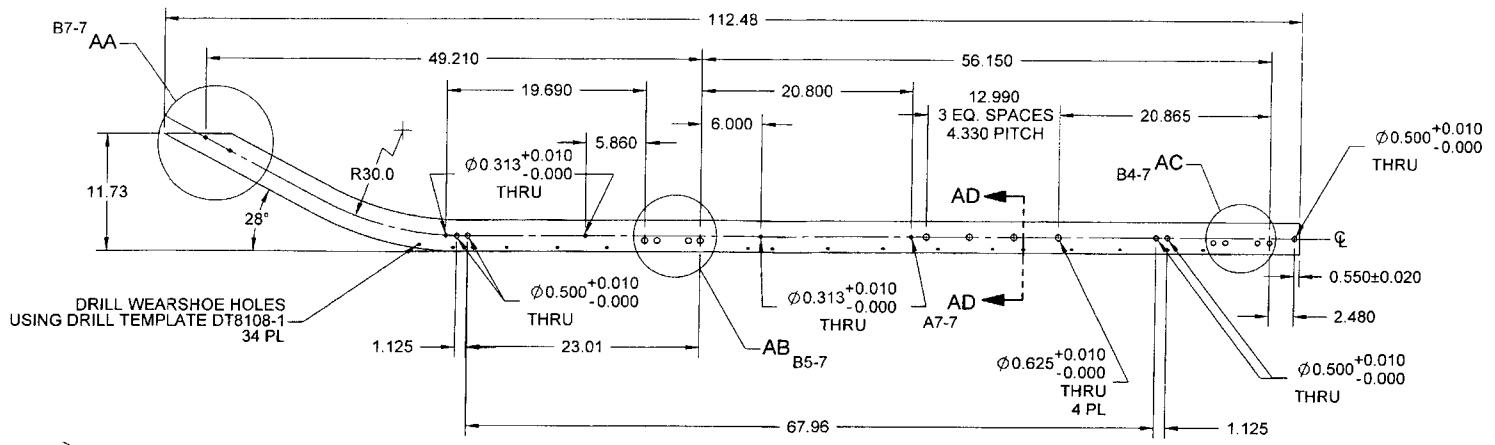
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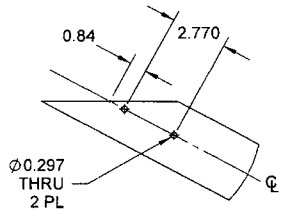
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

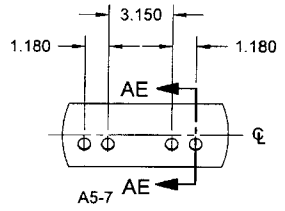
77131



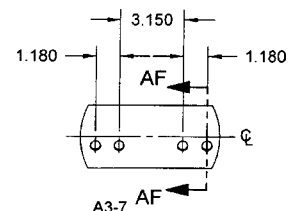
D2750-4 RH SKIDTUBE



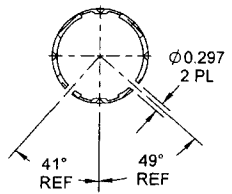
DETAIL AA
SCALE 2X



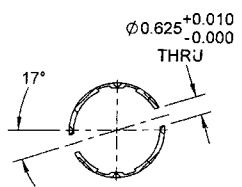
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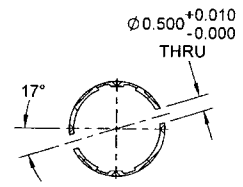
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

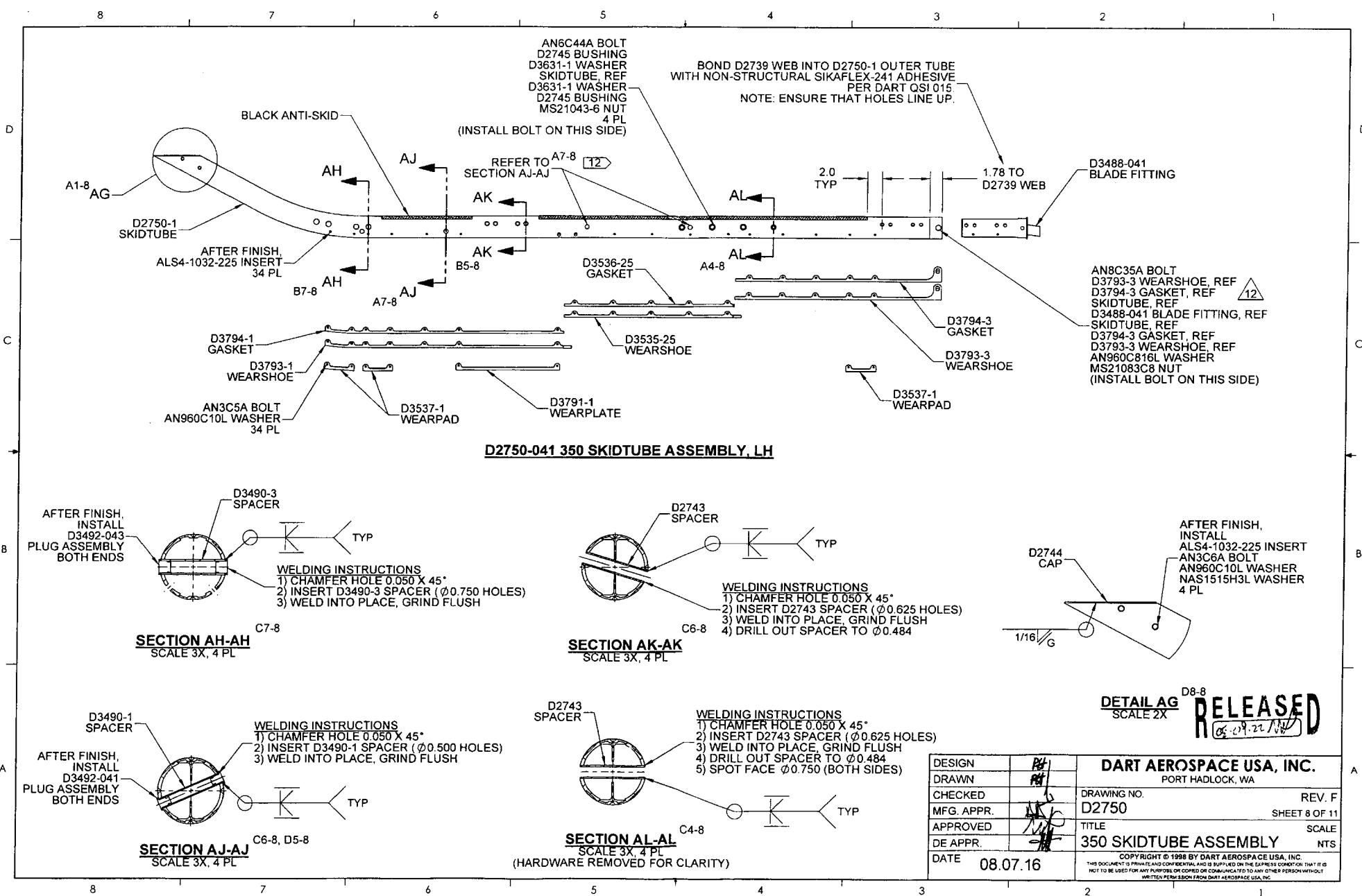
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN	<i>PH</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>PH</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 8 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

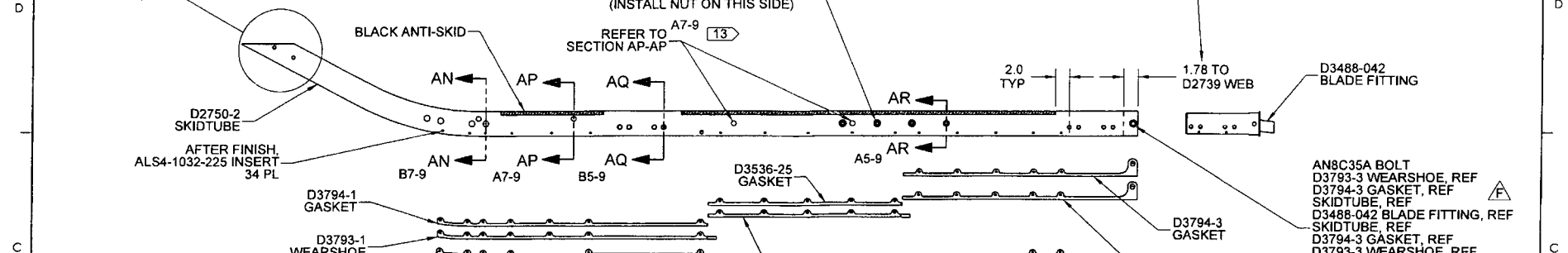
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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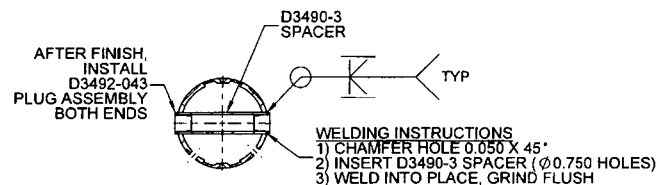
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

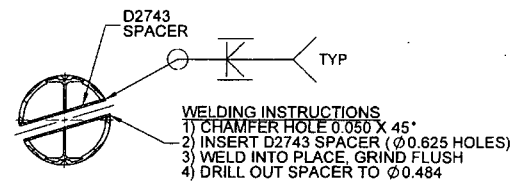
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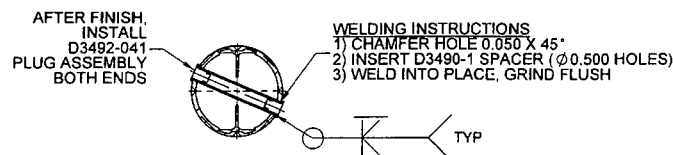
D2750-042 350 SKIDTUBE ASSEMBLY, RH



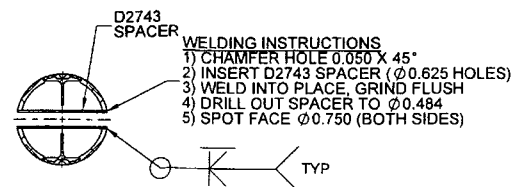
SECTION AN-AN
SCALE 3X, 4 PL



SECTION AQ-AQ
SCALE 3X, 4 PL

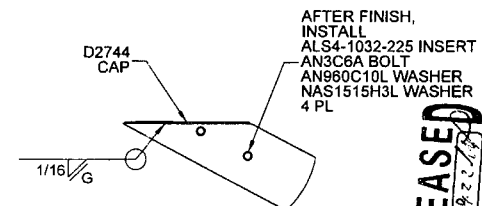


SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR

SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

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DRAWN	<i>PH</i>		SHEET 9 OF 11
CHECKED	<i>PH</i>		SCALE
MFG. APPR.	<i>MA</i>		NTS
APPROVED	<i>MA</i>		
DE APPR.	<i>MA</i>		
DATE	08.07.16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

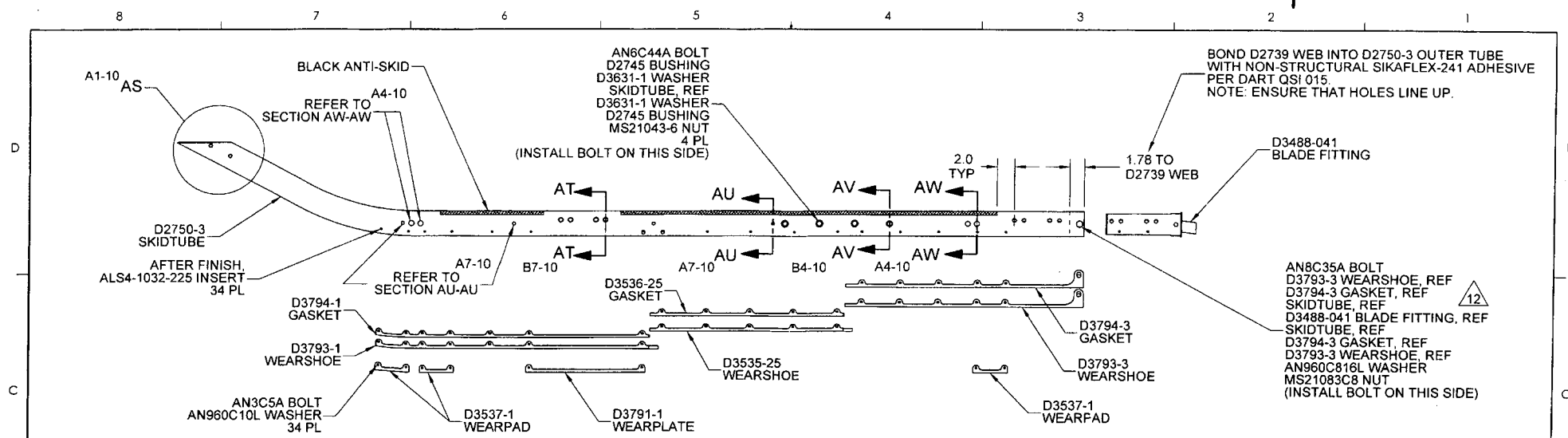
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

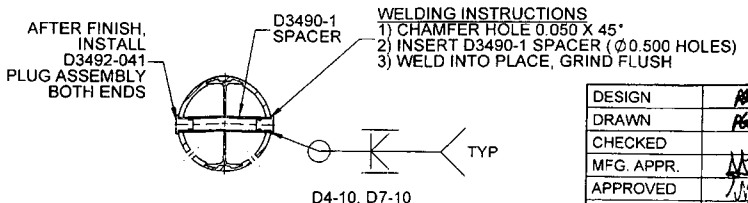
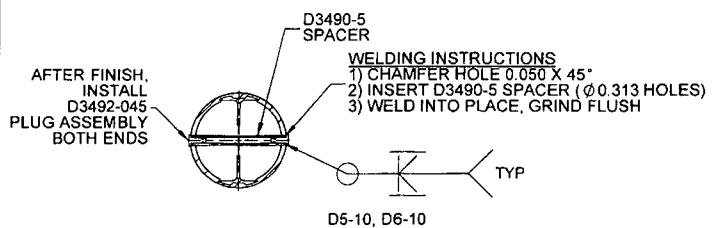
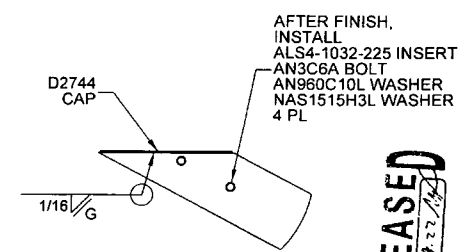
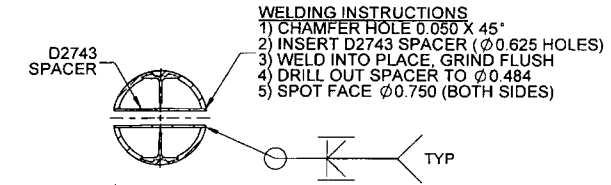
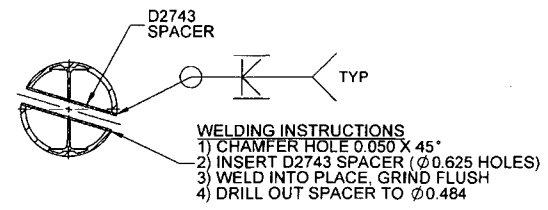
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77131



D2750-043 350 SKIDTUBE ASSEMBLY, LH



DESIGN		DART AEROSPACE USA, INC.
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. F
APPROVED		SHEET 10 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

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RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

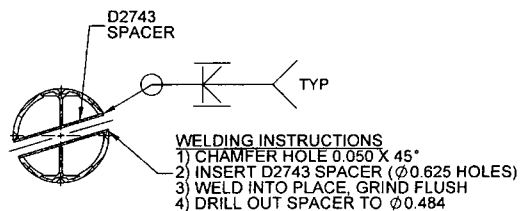
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

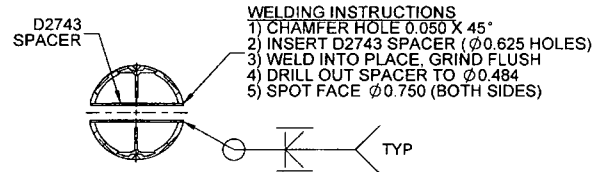
NOTE: Date & initial all entries



D2750-044 350 SKIDTUBE ASSEMBLY, RH

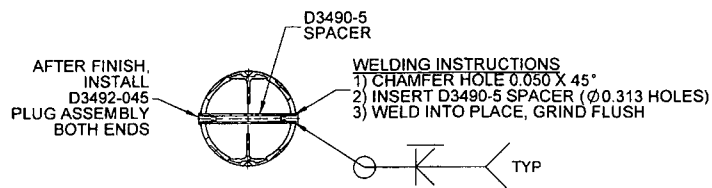


SECTION BB-BB
SCALE 3X, 4 PL

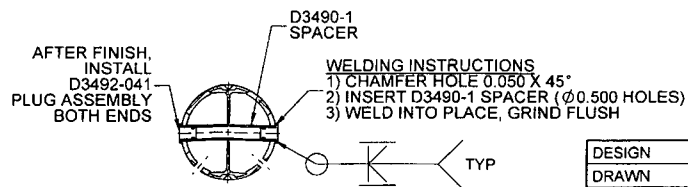


D4-11

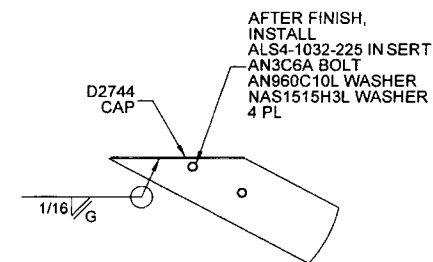
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA D8-11
SCALE 2X

DESIGN	<i>HA</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>HA</i>	PORT HADLOCK, WA	
CHECKED	<i>HA</i>	DRAWING NO.	REV. P
MFG. APPR.	<i>HA</i>	D2750	SHEET 11 OF 11
APPROVED	<i>HA</i>	TITLE	SCALE
DE APPR.	<i>HA</i>	350 SKIDTUBE ASSEMBLY	NTS
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 276

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barley Elliot
Job number: 75349
Part number: 350-636-016
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Smith Date of Test Coupon 11.11.22
Welder Barley Elliot Date of Test Coupon 11.11.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld